

# LOCTITE ABLESTIK 967-3

April 2014

## PRODUCT DESCRIPTION

LOCTITE ABLESTIK 967-3 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Brownish Grey
<b>Components</b>	Two component - requires mixing
<b>Mix Ratio - Part A:Part B</b>	1 : 1
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>Non-conductive</li> <li>Two component</li> <li>Low temperature cure</li> <li>Solvent-free formulation</li> </ul>
<b>Application</b>	Die attach

LOCTITE ABLESTIK 967-3 adhesive is designed for applications which require lower-than-normal cure temperatures. It is ideal for application by automatic dispenser, screen printing, or hand probe. This material is a electrically insulating version of ABLEBOND 967-1 adhesive.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	7,000
Work Life @ 25°C, days	2
Shelf Life (from date of manufacture):	
In kits @ 5°C, days	365
In kits @ 25°C, days	183
Premixed & Frozen @ -40°C, days	365

## TYPICAL CURING PERFORMANCE

### Cure Schedule

30 minutes @ 150°C

### Alternative Cure Schedule 1

6 hours @ 65°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties

Glass Transition Temperature (T <sub>g</sub> ) by TMA, °C	85
Thermal Conductivity @ 121°C, W/(m·K)	0.7
Extractable Ionic Content, ppm:	
Chloride (Cl <sup>-</sup> )	≤300
Sodium (Na <sup>+</sup> )	≤10
Potassium (K <sup>+</sup> )	≤30
Water Extract Conductivity, μmhos/cm	80

## Electrical Properties

Volume Resistivity, ohms-cm	2×10 <sup>13</sup>
Dielectric Constant @ 1kHz	4.3
Dissipation Factor @ 1kHz	0.025

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Miscellaneous

Die Shear Strength :

2 X 2 mm Gold, kg-f,

Substrate	@25°C
Gold	11

Lap Shear Strength :

2 X 2 mm Aluminum, psi,

Substrate	@25°C
Aluminum	≥1700

## GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

### THAWING:

1. Allow container to reach room temperature before use.
2. After removing from the freezer, set the syringes to stand vertically while thawing.
3. DO NOT open the container before contents reach 25°C temperature. Any moisture that collects on the thawed container should be removed prior to opening the container.
4. DO NOT re-freeze. Once thawed to -40°C, the adhesive should not be re-frozen.

### DIRECTIONS FOR USE

1. Thawed adhesive should immediately be placed on dispense equipment for use.
2. If the adhesive is transferred to a final dispensing reservoir, care must be exercised to avoid entrapment of contaminants and/or air into the adhesive.
3. Adhesive must be completely used within the product's recommended work life.

### 2-PART KIT MIXING DIRECTIONS

1. Mix component thoroughly before use.
2. For 2-part kits, blend equal weights of Parts A and B (1:1 ratio) thoroughly.
3. Scrape the sidewall and bottom of container repeatedly during mixing.
4. To ensure the absence of unmixed adhesive, transfer contents to a secondary, empty container and mix for an additional minute.

**Not for product specifications**

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Storage life of 2-component kits at room temperature (25°C max) is 6 months. At standard refrigeration temperature (5°C max), storage life is 1 year.

Storage life of premixed and frozen is 1 year at -40°C.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} = \text{N/mm}^2$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

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Reference 0.3